

ASAP

# Work Order ID 52980



Page 1

October 20, 2009 11:47:25 AM

Item ID: D3943-7

Accept



Setup Start



Revision ID: KB

Item Name: Stud

Stop



Start Date: 10/21/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-10-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

13943

B

10/10/29

0.00

100



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

FOLIO REV: N/A

DWG REV: KB

SA 09/10/24

2-DEBURR AS REQUIRED

\*\*\*\*\*TAP DRILL FOR 1/4"-28 IN CENTER OF PART\*\*\*\*\*

30 6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 09/10/24

30 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52980**

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Item ID: D3943-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Stud

Start Date: 10/21/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

mf 09/10/26

30

0

130



Packaging

Packaging

Identify as per dwg & Stock Location: B9C

0.00

Memo

0.00

09/14/27 (B)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/18  
mf  
09-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October 20, 2009 11:47:25 AM

Page 1

Work Order ID: 52980



Parent Item: D3943-7RevA



Parent Item Name: Stud

Start Date: 10/21/2009

Required Date: 10/23/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010R0.375 		Purchased	No			100	f	12.0000	0.2000			

ROUND BAR .375

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

12

112886

12

*Full 09.10.29*

M1018 R.B. .375 → M111860 ??

3P+

SA 09/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

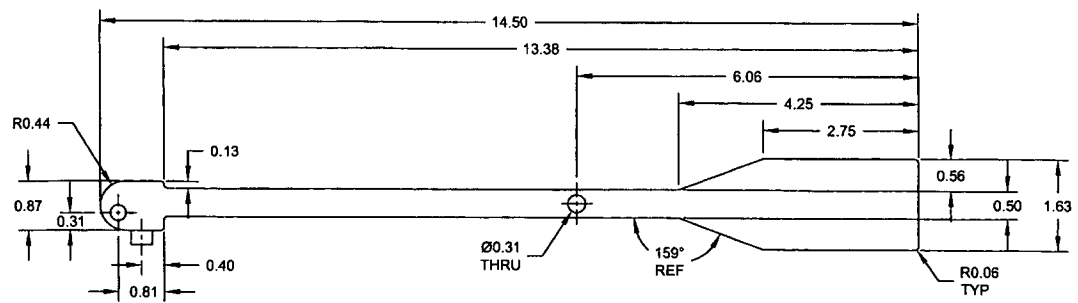
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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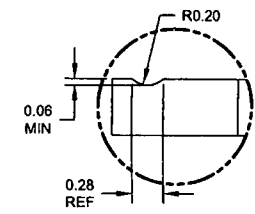
**NOTE:** Date & initial all entries



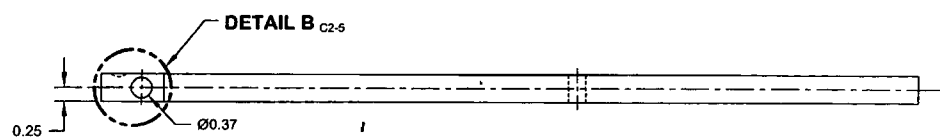
8 7 6 5 4 3 2 1



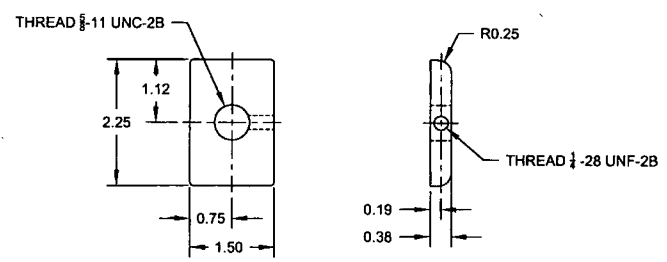
#52980



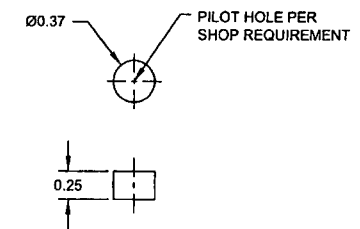
**DETAIL B-B** C7-5  
(Dimple Detail)  
(Scale 2X)



**D3943-3 HANDLE EXTENSION**



**D3943-5 PLATE**



**D3943-7 STUD**  
(Scale 2X)

**NOTES -11/-13:**

- 1) MATERIAL -3 & -5: MILD STEEL, SHEET  
AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
REF DART SPEC M1010-S
- OR: MILD STEEL, BAR  
AISI 1010-1025 OR ASTM A36/A366/A569/A570  
OR CSA G40-21, 38W/44W/50W/60W/70W  
REF DART SPEC M1010-B
- 7: MILD STEEL, ROUND BAR  
AISI 1018-1025  
PER MIL-S-7097  
REF DART SPEC M1018-R
- 2) FINISH -3: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

**RELEASED**  
2009-10-19

DESIGN	DSTOW / AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.10.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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